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K6A 1K7
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D350-591-113
Job Sheet 195530



Part No: D350-591-113

Job Qty: 10 pcs

Part Name: Heli-Access Step, Short, High Gear



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/24/19

Job Tracking No:

Due Date: 8/20/19

Created By: Marie Lajeunesse

Type: SOLD

Description: order 16536

Note: DWG DSI 9525 REV A, D2310 REV D IPP Rev:H 04.11.09 Reformat KJ/JLM IPP Rev:E as per ECN10-586
10.06.18 DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Large Fab - Steps - 1	10 pcs	8/20/19		0.00	20.00	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		Jx
115	QC 5	10 pcs	8/20/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
120	Conventional Mill - 1 - B4B	10 pcs	8/20/19		0.00	1.67	Conventional Mill - 1 - B4B		
							Conventional Mill - 2 - B4B		

PRIORITY

DAS
24
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JUN 18 2019

125 QC 2	10 pcs	8/20/19	0.00 0.00	QC 2 - 1	
				QC 2 - 12	
				QC 2 - 14	
				QC 2 - 17	
				QC 2 - 19	
				QC 2 - 2	
				QC 2 - 20	
				QC 2 - 22	
				QC 2 - 23	
				QC 2 - 25	
				QC 2 - 32	
				QC 2 - 33	
				QC 2 - 35	
				QC 2 - 39	
				QC 2 - 4	
				QC 2 - 40	
				QC 2 - 44	
				QC 2 - 45	
				QC 2 - 48	
				QC 2 - 49	
				QC 2 - 50	
				QC 2 - 51	
				QC 2 - 52	
				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
130 QC 8	10 pcs	8/20/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
135 Large Fab - Welded Assy-2-B4B	10 pcs	8/20/19	0.00 10.00	Large Fab - 1 - B4B	
				Large Fab - 10 - B4B	

1/19/7/22

1/19/7/22

5/24/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

						Large Fab - 2 - B4B	
						Large Fab - 3 - B4B	
						Large Fab - 4 - B4B	
						Large Fab - 5 - B4B	
						Large Fab - 6 - B4B	
						Large Fab - 7 - B4B	
						Large Fab - 8 - B4B	
						Large Fab - 9 - B4B	
						QC 5 - 10	
140 QC 5	10 pcs	8/20/19	0.00	0.00		QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 9 - 10	
						QC 9 - 18	
						QC 9 - 24	
150 QC 9	10 pcs	8/20/19	0.00	0.00		QC 9 - 43	
						QC 9 - 50	
						QC 9 - 9	
						Handfinish - 1 - 1 - B4B	
						Handfinish - 1 - 2 - B4B	
165 Handfinish - 1-1 Chemical-B4B	10 pcs	8/20/19	0.00	2.22		Handfinish - 1 - 3 - B4B	
						Handfinish - 1 - 4 - B4B	
						Handfinish - 1 - 5 - B4B	
						Handfinish - 1 - 6 - B4B	
						Handfinish - 1 - 7 - B4B	
						Handfinish - 1 - 8 - B4B	
						Handfinish - 1 - 9 - B4B	
						Handfinish - 1 - 10 - B4B	
						Handfinish - 1 - 11 - B4B	
						Handfinish - 1 - 12 - B4B	
						Handfinish - 1 - 13 - B4B	
						Handfinish - 1 - 14 - B4B	
						Handfinish - 1 - 15 - B4B	
						Handfinish - 1 - 16 - B4B	
						Handfinish - 1 - 17 - B4B	
						Handfinish - 1 - 18 - B4B	
						Handfinish - 1 - 19 - B4B	
						Handfinish - 1 - 20 -	

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				B4B		
				Handfinish - 1 - 21 - B4B		
				Handfinish - 1 - 22 - B4B		
170 Large Fab - Steps - 2 - B4B	10 pcs	8/20/19	0.00 10.32	Large Fab - 1 - B4B		SLN
				Large Fab - 10 - B4B		
				Large Fab - 2 - B4B		
				Large Fab - 3 - B4B		
				Large Fab - 4 - B4B		
				Large Fab - 5 - B4B		
				Large Fab - 6 - B4B		
				Large Fab - 7 - B4B		
				Large Fab - 8 - B4B		
				Large Fab - 9 - B4B		
180 QC 10	10 pcs	8/20/19	0.00 0.00	QC 10 - 10		
				QC 10 - 18		
				QC 10 - 24	DAS 24	AUG 21 2019
				QC 10 - 43	9-89	
				QC 10 - 50	9-89	
				QC 10 - 58		
				QC 10 - 9		
190 QC 5	10 pcs	8/20/19	0.00 0.00	QC 5 - 10		
				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		
				QC 5 - 19	DAS 24	AUG 21 2019
				QC 5 - 22	9-89	
				QC 5 - 24	9-89	
				QC 5 - 3		
				QC 5 - 43		
				QC 5 - 49		
				QC 5 - 51		
				QC 5 - 58		
				QC 5 - 68		
				QC 5 - 9		
				QC 5 - 50		
				QC 5 - 30		
				QC 5 - 40		
200 Handfinish - 1-2- Chemical-B4B	10 pcs	8/20/19	0.00 2.22	Handfinish - 1 - 1 - B4B		13 FEB 19-08-22
				Handfinish - 1 - 2 - B4B		
				Handfinish - 1 - 3 - B4B		
				Handfinish - 1 - 4 - B4B		
				Handfinish - 1 - 5 - B4B		
				Handfinish - 1 - 6 - B4B		
				Handfinish - 1 - 7 - B4B		
				Handfinish - 1 - 8 - B4B		
				Handfinish - 1 - 9 - B4B		
				Handfinish - 1 - 10 - B4B		
				Handfinish - 1 - 11 - B4B		
				Handfinish - 1 - 12 - B4B		
				Handfinish - 1 - 13 - B4B		
				Handfinish - 1 - 14 - B4B		
				Handfinish - 1 - 15 - B4B		

						Handfinish - 1 - 16 - B4B	
						Handfinish - 1 - 17 - B4B	
						Handfinish - 1 - 18 - B4B	
						Handfinish - 1 - 19 - B4B	
						Handfinish - 1 - 20 - B4B	
						Handfinish - 1 - 21 - B4B	
						Handfinish - 1 - 22 - B4B	
210 Powdercoat - 1 White Gl(A)- B4B	10 pcs	8/20/19	0.00	2.06		Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	
						Powdercoat - 4 - B4B	
220 Handfinish - 3-1- WingWalk- B4B	10 pcs	8/20/19	0.00	2.22		Handfinish - 3 - 1 - B4B	
						Handfinish - 3 - 2 - B4B	
						Handfinish - 3 - 3 - B4B	
						Handfinish - 3 - 4 - B4B	
						Handfinish - 3 - 5 - B4B	
230 QC 3	10 pcs	8/20/19	0.00	0.00		QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
240 Packaging 1-1 - Pick Kit - B4B	10 pcs	8/20/19	0.00	0.00		Packaging 1 - 1 - B4B	
						Packaging 1 - 2 - B4B	
						Packaging 1 - 3 - B4B	
						Packaging 1 - 4 - B4B	
						Packaging 1 - 5 - B4B	
						Packaging 1 - 6 - B4B	
						Packaging 1 - 7 - B4B	
						Packaging 1 - 8 - B4B	
						Packaging 1 - 9 - B4B	
						Packaging 1 - 10 - B4B	
						Packaging 1 - 11 - B4B	
						Packaging 1 - 12 - B4B	
						Packaging 1 - 13 - B4B	
						Packaging 1 - 14 - B4B	
						Packaging 1 - 15 - B4B	
						Packaging 1 - 16 - B4B	

				Packaging 1 - 17 - B4B	
				Packaging 1 - 18 - B4B	
				Packaging 1 - 19 - B4B	
				Packaging 1 - 20 - B4B	
				Packaging 1 - 21 - B4B	
				Packaging 1 - 22 - B4B	
				Packaging 1 - 23 - B4B	
				Packaging 1 - 24 - B4B	
				Packaging 1 - 25 - B4B	
				Packaging 1 - 26 - B4B	
				Packaging 1 - 27 - B4B	
				Packaging 1 - 28 - B4B	
				Packaging 1 - 29 - B4B	
				Packaging 1 - 30 - B4B	
				Packaging 1 - 31 - B4B	
				Packaging 1 - 32 - B4B	
				Packaging 1 - 33 - B4B	
				Packaging 1 - 34 - B4B	
				Packaging 1 - 35 - B4B	
				Packaging 1 - 36	
250 QC 4	10 pcs	8/20/19	0.00 0.00	QC 4 - 28	
				QC 4 - 58	
				QC 4 - 69	
				QC 4 - 9	
				QC 4 - 46	
				QC 4 - 68	
				QC 4 - 72	
				QC 4 - 74	
260 Packaging 3-1 - Stock - B4B	10 pcs	8/20/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	

Max B

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M44

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				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	21
265 DC - 1 - B4B	10 pcs	8/20/19	0.00 0.00	DC - 1 - B4B	9-55 AUG 29 2019
				DC - 2 - B4B	
270 QC 21 - FG	10 pcs	8/20/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	21
				QC 21 - SA - 53	AUG 29 2019

Part Op 110 - (Fabricate per Dwg) 1- Cut D2244 extrusion to 62.00" long as per Dwg D2310 2- Drill extrusion as per Dwg D2310
 Descriptions: using drill Jig DT8230

115 -

120 - 1- OPEN HOLE FOR BUSHING TO SIZE AS PER DWG AND: C'SINK.

135 - 1- Weld Fwd end cap and bushing as per Dwg D2310 A/R AL ROD Batch: 138872 2- Grind end cap and bottom bushing welds flush 3- Machine top weld on bushing flush as per dwg.

140 - (QC5- Inspect part completeness to step on W/O)

165 - (Chemical Conversion Coat per QSI005 4.1)

170 - (Weld per dwg A/R Aluminum rod Batch: 138872 1-Rivet as per Dwg D2310 3-Weld Aft end cap as per Dwg D2310 A/R AL ROD Batch: 138872 4-Grind end cap welds flush

180 - (QC10- Inspect visual per QSI004- ground welds)

190 - (QC5- Inspect part completeness to step on W/O)

200 - (Chemical Conversion Coat per QSI005 4.1)

210 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ FINISH TIME: _____

220 - (Wing Walk as per dwg QSI005 4.4 Batch 5155112 ***Install Dart labels after wing walk***

230 - (QC3- Inspect Part Finish) ***Install Dart labels after wing walk***

240 - (Pick Kit)

250 - (QC4- 100% Inspect kits for completeness)

260 - (Identify as per dwg & Stock Location: _____) Identify and pack for shipping as per PPP D350-591-113

265 - (Document Control) Photocopy bluefile & type labels per PPP D350-591-113 CHG005

270 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2244-116	Step Extrusion	10 pcs (1 ea)	110-Large Fab - Steps - 1	5081118
D2275	Bushing	10 pcs (1 ea)	135-Large Fab - Welded Assy-2- B4B	5196715 515898-4
D2673-34	End Plate	10 pcs (1 ea)	135-Large Fab - Welded Assy-2- B4B	5192727
D2582	Hi-Skid Step Leg Assembly	10 pcs (1 ea)	170-Large Fab - Steps - 2 - B4B	5007030
D2673-34	End Plate	10 pcs (1 ea)	170-Large Fab - Steps - 2 - B4B	5192727
MS20600-AD4W3	Cherry Rivet	160 Ea (16 ea)	170-Large Fab - Steps - 2 - B4B	5155708
K591-113	Short Step Installation	10 pcs (1 ea)	240-Packaging 1-1 - Pick Kit - B4B	5209511

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Steps - 1	D2244-116	10	20	0
135-Large Fab - Welded Assy-2- B4B	D2275	10	4	0
	D2673-34	10	9	0
170-Large Fab - Steps - 2 - B4B	D2582	10	3	0
	D2673-34	10	9	0
	MS20600-AD4W3	160	356	0
240-Packaging 1-1 - Pick Kit - B4B	K591-113	10	2	0

Part Specifications

Specifications could not be found.

Plex 5/24/19 1:03 PM Dart.lajeunesse.marie

Route update only

H:/FORMS/Quality Assurance/approved QA/NCRWO Rev J

